

Work Order ID 66062

Thursday, February 03, 2011 11:44:05 AM



ASAP

Page 1

Item ID: D206-810-011

Accept



Setup Start



Revision ID: PRELIM

Item Name: Basket Modification

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE *AS*

Required Date: 2/11/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-810

PA 15 11.02 24 *AS*

0.00

100



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-810-011 CHG001

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg D206-810

21 11-02-17 *(X)*
(PTO)

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*inspector to
part Day
only
Sublock*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-02-16	110	Paint parts D4326-1, D4326-3, D4326-5 cover panel + spacers using Glasurit 22 line Urethane Acrylic mix as per manufacturer's specs. use 285-60 grey use Glasurit 285-60 grey primer filler mix as per					
11-02-16	110	QSI 005 + use 865 Adhesion promoter. Follow preparation + application instructions as per QSI 005					

Not for this W/O

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 66062

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-02-23	110	add to pick list NAS43004-46 x1 B 111886 MS27039-1-21 x1 B 115935 NAS1149003635 x2 B 116007 MS27039-1-23 x2 B 116007	BT	11-02-23	7		
11-02-23	110	use 2 NAS 1149 003635 washers instead of NAS 1149 003305 due to lack of stock NAS 1149 003635 x 2 B 116007 use 1 MS27039-1-23 screw to replace MS27039-1-21 screw. -21 too short because of thicker washers MS27039-1-23 B 18251	BT	11-02-23		11/02/23	

Part No: D206-810-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 66062		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-02-24	110	When installing D4319-1 altimeter bracket use D4319-3 spacer: change AN4-6A Bolts that hold D4319-1 Bracket to AN4-10A Bolts. (bolt need to be longer because of spacer) D4319-3 spacer B <u>66639</u> x1 AN4-10A Bolt m <u>115835</u> x4	BT	11-02-24		11-02-24 S. O. A. Z.	

Part No: D206-810-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66062

Thursday, February 03, 2011 11:44:05 AM



Page 2

Item ID: D206-810-011

Accept



Setup Start



Revision ID: PRELIM

Item Name: Basket Modification

Stop



Start Date: 2/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D206-810-011								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

S/O 103706
cust. plan

C/O F/C ONLY
NON AIRWORTHY

11/03/03
U 11-0301

POSITIVE RECALL

EFFECTIVE 11/03/03 AUTH U

RELEASED U DATE 11.03.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, February 03, 2011 11:44:01 AM

Parent Item: D206-810-011

















Parent Item Name: Basket Modification

Start Date: 2/4/2011**Required Date:** 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9542-041 		Manufactured	No			110	Each	0.0000	1	1			
Basket Modification													
D4317-7 		Manufactured	No			110	Each	0.0000	1	1			
GPS Plate												ST 11-02-17	
D4318-011 		Manufactured	No			110	Each	0.0000	1	1			
Deck Assembly												ST 11-02-17	
D4319-1 		Manufactured	No			110	Each	0.0000	1	1			
Altimeter Bracket												ST 11-02-17	
D4320-1 		Manufactured	No			110	Each	0.0000	4	4			
Angle Bracket												ST 11-02-17	
D4326-1 		Manufactured	No			110	Each	0.0000	1	1			
Cover Panel, Top												ST 11-02-17	
D4326-3 		Manufactured	No			110	Each	0.0000	2	2			
Cover Panel, Ends												ST 11-02-17	
D4326-5 		Manufactured	No			110	Each	0.0000	1	1			
GPS Plate Spacer												ST 11-02-17	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:44:01 AM

Page 2

Work Order ID: 66062

Parent Item: D206-810-011

Parent Item Name: Basket Modification

Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-4A

Purchased

No

110

Each

160.0000

26



Bolt



2627 as per Rev PAS

RT 11-02-17

Location

Loc Qty

Loc Code

ST356

159

114615

159

ST361

1

111295

1

110

Each

441.0000

AN4-5A

Purchased

No



BOLT



128 x 27

Location

Loc Qty

Loc Code

ST346

441

110552

1

112243

440

110

Each

359.0000

AN4-6A

Purchased

No



Bolt



1115457

12 12

RT 11-02-17

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

255

113121

1

115016

16

116003

188

116400

50

ST358

100

116704

100

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:44:02 AM

Page 3

Work Order ID: 66062

Parent Item: D206-810-011

Parent Item Name: Basket Modification

Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-12A
Bolt

Purchased

No

110

Each

266.0000

7

7



RT 11-02-17

Location

Loc Qty

Loc Code

ST357

266

112314

66

115371

40

115422

160

X7

AN970-4

Purchased

No

110

Each

67.0000

36



Washer



28 37 as per Rev P45
RT 11-02-17

Location

Loc Qty

Loc Code

ST344

67

115936

67

MS21043-3

Purchased

No

110

Each

1,422.000

3



Nut



X36 x37
8 x 4 as per Rev P45
25 11-02-17

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1346

112314

1346

X3 x4

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:44:02 AM

Page 4

Work Order ID: 66062

Parent Item: D206-810-011

Parent Item Name: Basket Modification

Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,073.000

17

17



Nut



BT 11-02-17

Location

Loc Qty

Loc Code

ST301

1073

114523

5

114784

2

115936

170

116188

596

116549

300

X17

MS27039-1-08

Purchased

No

110

Each

1,222.000

3

3



Screw



BT 11-02-17

Location

Loc Qty

Loc Code

ST291

1222

110835

367

115108

855

X3

NAS1149A0332J

Purchased

No

110

Each

3,890.000

6



Washer



68 ~~BT 11-02-17~~ BT 11-02-17

BT 11-02-17

Location

Loc Qty

Loc Code

ST297

3890

115000

125

115698

35

116025

730

116304

3000

Thursday, February 03, 2011 11:44:02 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 11:44:02 AM

Page 5

Work Order ID: 66062



Parent Item: D206-810-011



Parent Item Name: Basket Modification

Start Date: 2/4/2011

Required Date: 2/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

1,346.000



Washer

26 1826
 11 02-17

Location

Loc Qty

Loc Code

ST297

983

116304

983

x 26

ST298

363

110914

4

115622

38

116025

118

116289

203

11-02-24
 A4319-3 qty 1 B# 66639
 A4319-5 qty 2 B# 66640

21 11-02-24

21 11-02-24

Thursday, February 03, 2011 11:44:02 AM

Shop Packet Print

Page 5

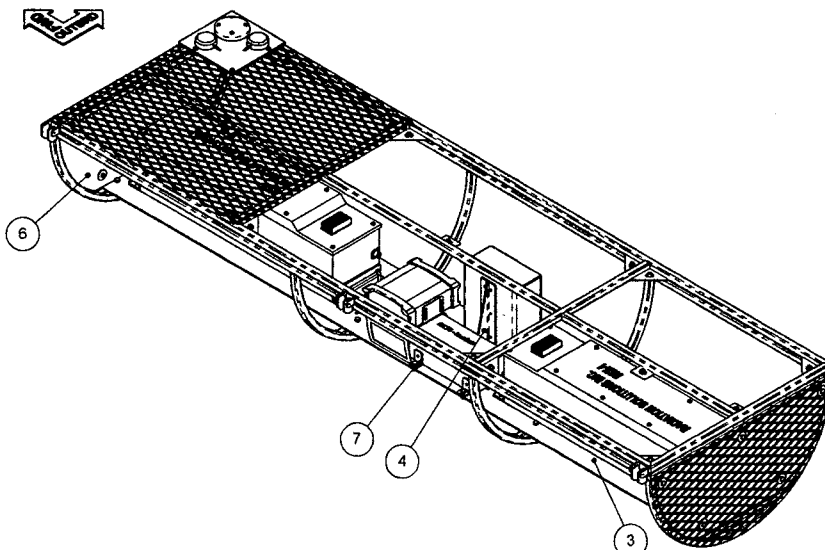
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

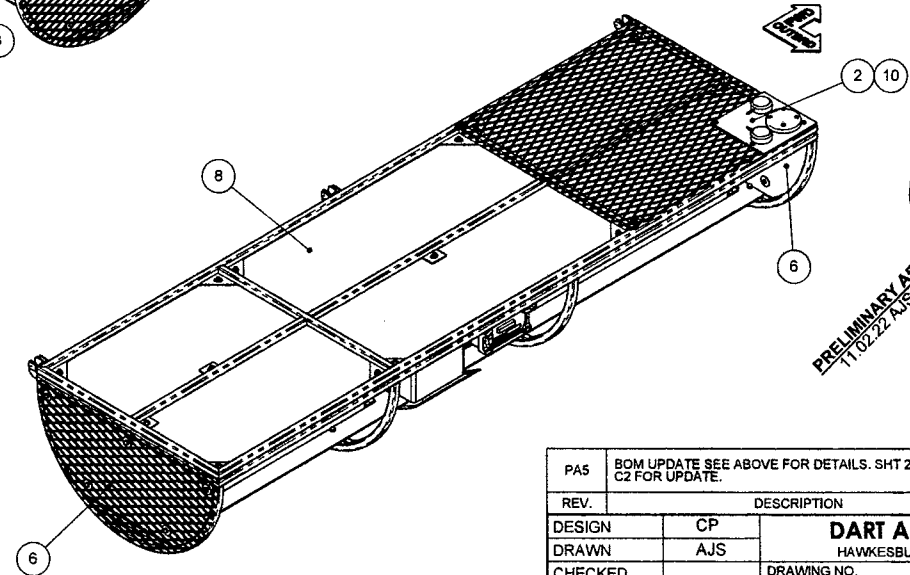
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D206-810-011 BASKET EQUIPMENT INSTALLATION
(ITEM 7 NOT SHOWN FOR CLARITY
EXPANDED METAL SHOWN LOCALLY FOR CLARITY
ELECTRICAL EQUIPMENT SHOWN FOR REF ONLY)



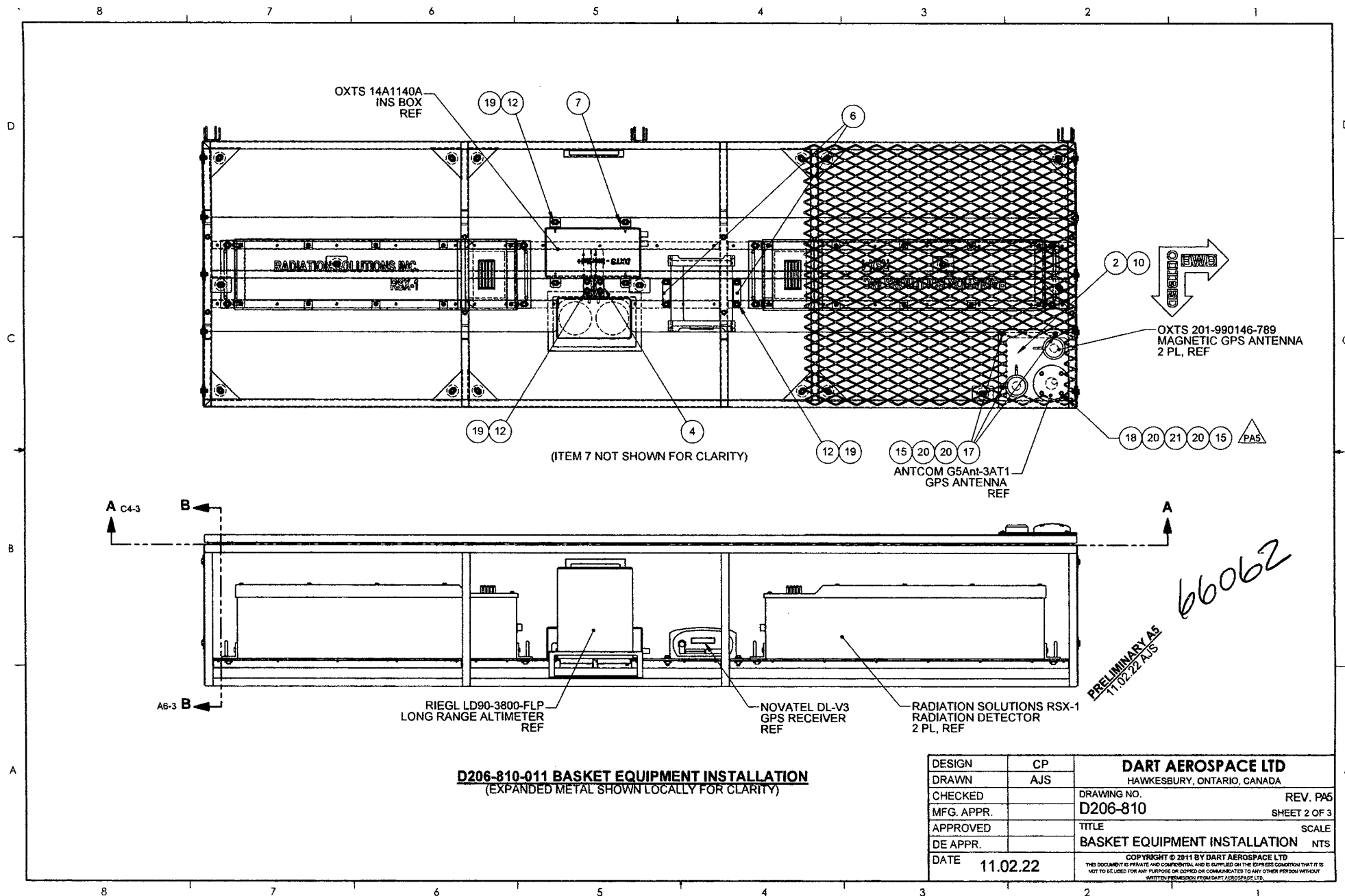
ITEM	QTY -011	P/N	DESCRIPTION
	X	D206-810-011	BASKET EQUIPMENT INSTALLATION
1	1	D4317-043	COVER PANEL RETAINER
2	1	D4317-7	GPS PLATE
3	1	D4318-041	DECK ASSEMBLY
4	1	D4319-1	ALTIMETER BRACKET
5	1	D4319-3	SPACER
6	2	D4319-5	GPS BRACKET
7	4	D4320-1	ANGLE BRACKET
8	1	D4326-1	COVER PANEL (TOP)
9	2	D4326-3	COVER PANEL (ENDS)
10	1	D4326-5	GPS PLATE SPACER
11	26	AN4-4A	BOLT
12	12	AN4-6A	BOLT
13	7	AN4-12A	BOLT
14	36	AN970-4	WASHER
15	4	MS21043-3	NUT
16	17	MS21043-4	NUT
17	3	MS27039-1-08	SCREW
18	1	MS27039-1-21	SCREW
19	26	NAS1149D0463J	WASHER
20	8	NAS1149D0332J	WASHER
21	1	NAS43DD4-46	SPACER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) THIS INSTALLATION ADDS 134 LBS TO THE WEIGHT OF THE BASKET. THE BASKET SHOULD NOT BE USED FOR CARRYING OTHER TYPES OF CARGO WHEN THE D206-810-011 KIT IS INSTALLED.
 - 8) LOCATE ITEMS 8, 11 & 13 APPROX AS SHOWN, DRILL $\phi 0.257$ HOLE CENTERED ON THE VOID IN THE MESH AS SHOWN IN SECTION B-B DETAIL A
 - 9) THIS INSTALLATION REQUIRES BASKET MODIFICATION PER DSI 9542

PA5	BOM UPDATE SEE ABOVE FOR DETAILS. SHT 2 SEE ZONE C2 FOR UPDATE.		AJS	11.02.22
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. PA5	
MFG. APPR.		D206-810	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		BASKET EQUIPMENT INSTALLATION	NTS	
DATE	11.02.22		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

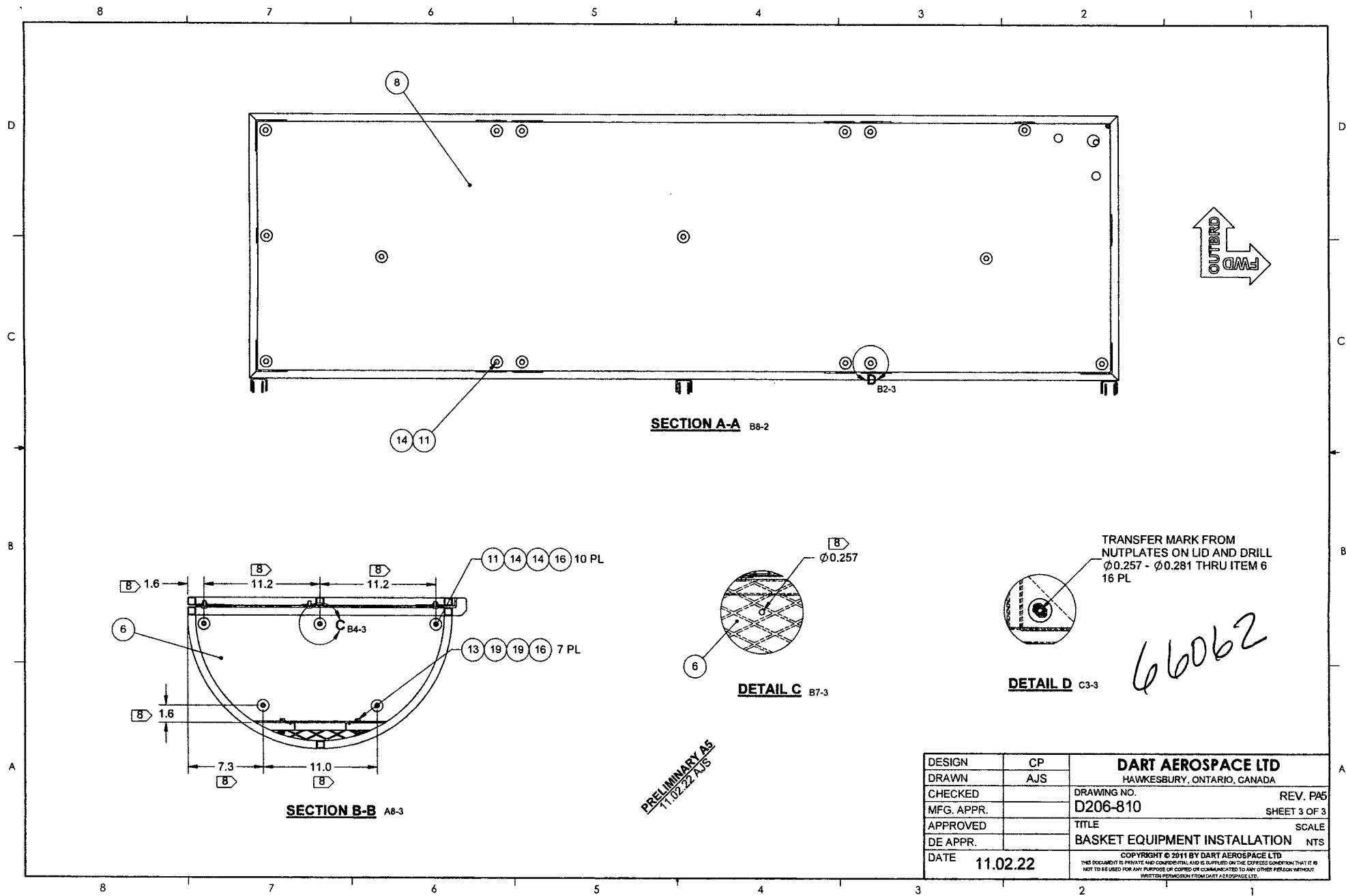
66062

PRELIMINARY A5
11.02.22 AJS

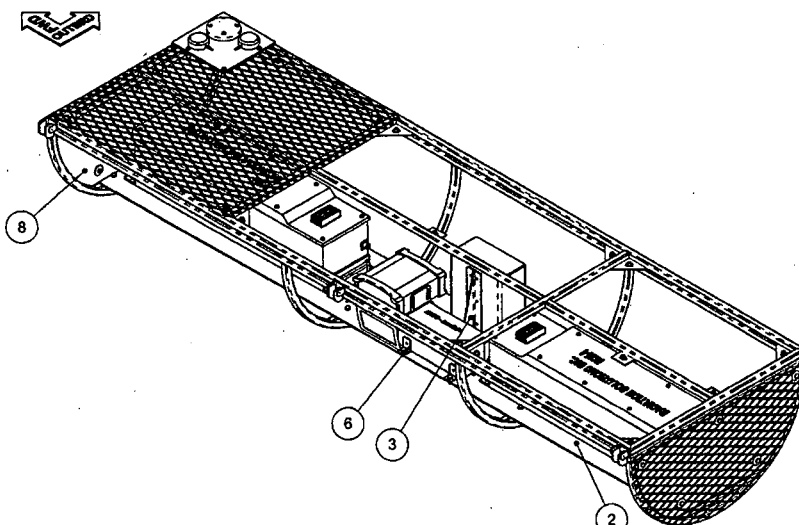


D206-810-011 BASKET EQUIPMENT INSTALLATION
(EXPANDED METAL SHOWN LOCALLY FOR CLARITY)

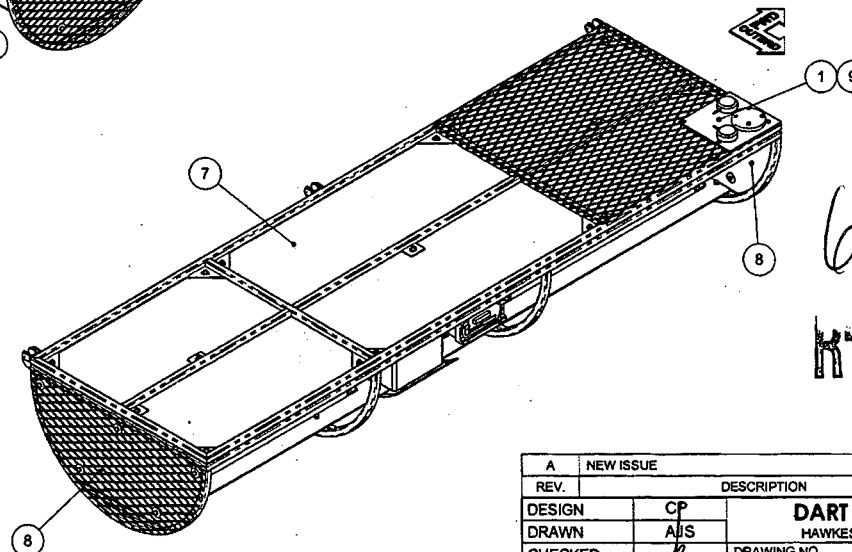
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PA6
MFG. APPR.		D206-810	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET EQUIPMENT INSTALLATION	NTS
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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D206-810	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET EQUIPMENT INSTALLATION	NTS
DATE	11.02.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D206-810-011 BASKET EQUIPMENT INSTALLATION
 (ITEM 7 NOT SHOWN FOR CLARITY)
 EXPANDED METAL SHOWN LOCALLY FOR CLARITY
 ELECTRICAL EQUIPMENT SHOWN FOR REF ONLY



ITEM	QTY -011	P/N	DESCRIPTION
	X	D206-810-011	BASKET EQUIPMENT INSTALLATION
1	1	D4317-7	GPS PLATE
2	1	D4318-041	DECK ASSEMBLY
3	1	D4319-1	ALTIMETER BRACKET
4	1	D4319-3	SPACER
5	2	D4319-5	GPS BRACKET
6	4	D4320-1	ANGLE BRACKET
7	1	D4326-1	COVER PANEL (TOP)
8	2	D4326-3	COVER PANEL (ENDS)
9	1	D4326-5	GPS PLATE SPACER
10	26	AN4-4A	BOLT
11	12	AN4-6A	BOLT
12	7	AN4-12A	BOLT
13	36	AN970-4	WASHER
14	4	MS21043-3	NUT
15	17	MS21043-4	NUT
16	2	MS27039-1-08	SCREW
17	2	MS27039-1-21	SCREW
18	26	NAS1149D0463J	WASHER
19	8	NAS1149D0332J	WASHER
20	2	NAS43DD4-46	SPACER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) THIS INSTALLATION ADDS 134 LBS TO THE WEIGHT OF THE BASKET. THE BASKET SHOULD NOT BE USED FOR CARRYING OTHER TYPES OF CARGO WHEN THE D206-810-011 KIT IS INSTALLED.
- 8) LOCATE ITEMS 10, 13 & 15 APPROX AS SHOWN. DRILL $\varnothing 0.257$ HOLE CENTERED ON THE VOID IN THE MESH AS SHOWN IN SECTION B-B DETAIL A
- 9) THIS INSTALLATION REQUIRES BASKET MODIFICATION PER DSI 9542

66062
 RELEASED
 2011-03-03

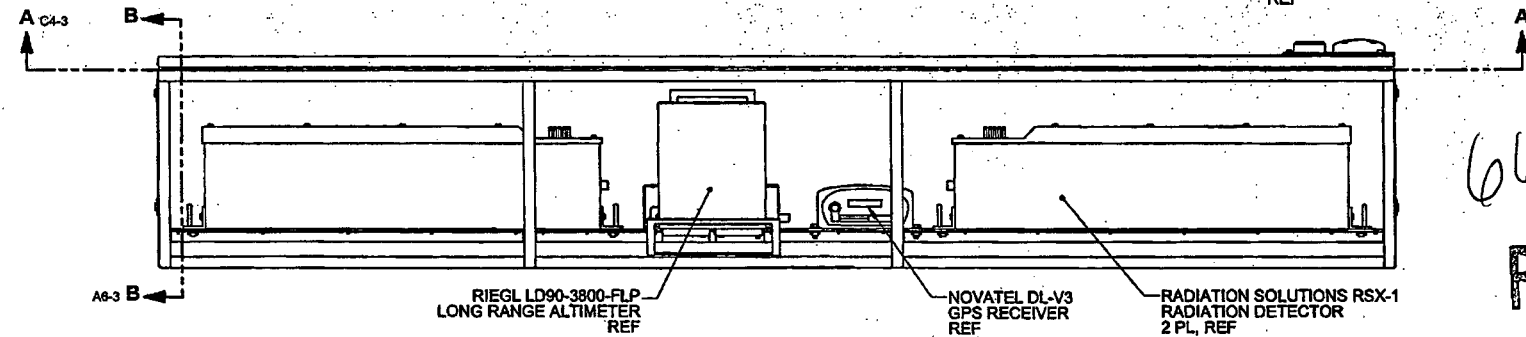
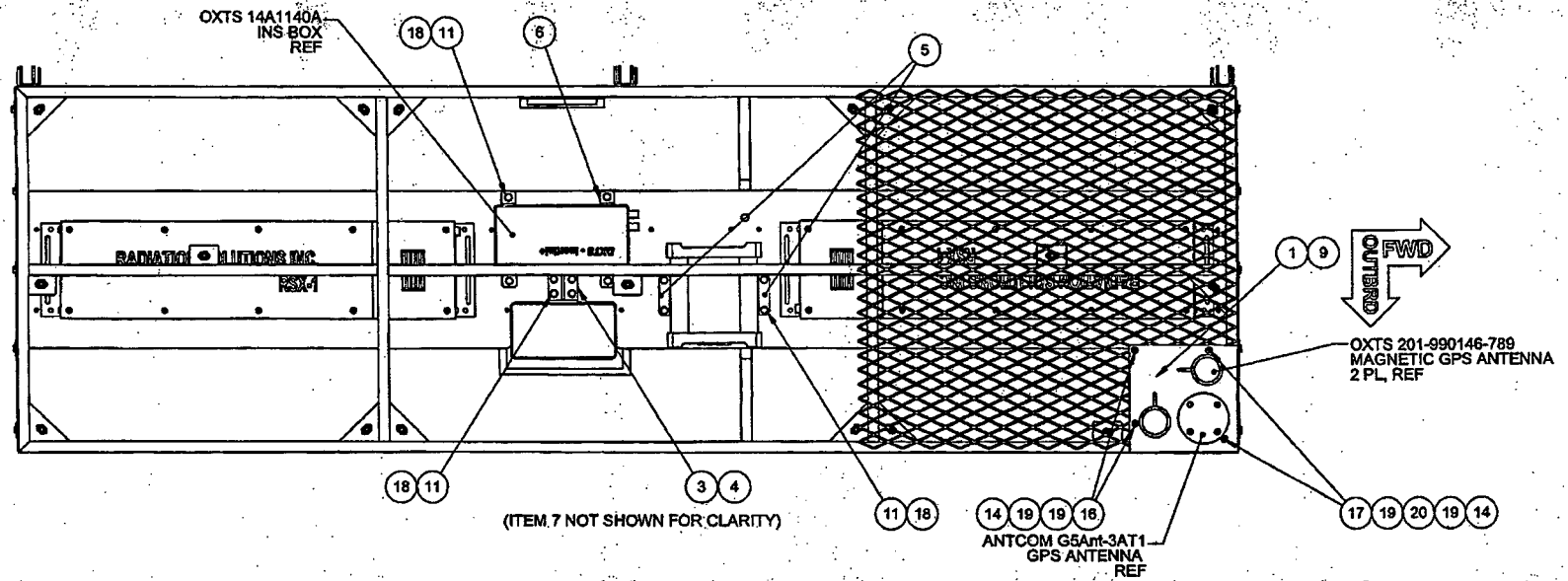
A	NEW ISSUE	AJS	11.02.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	AJS		
CHECKED	B		
MFG. APPR.	B		
APPROVED	17		
DE APPR.	17		
DATE	11.02.15		

DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D206-810
 SHEET 1 OF 3
 TITLE BASKET EQUIPMENT INSTALLATION
 SCALE NTS

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8 7 6 5 4 3 2 1



66062

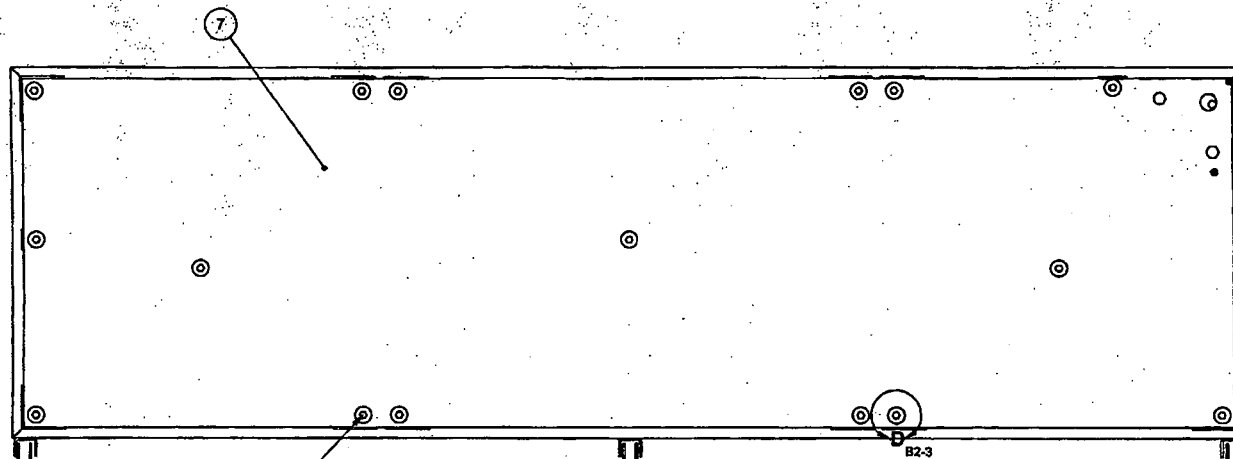
RELEASED
2011-03-03

D206-810-011 BASKET EQUIPMENT INSTALLATION
(EXPANDED METAL SHOWN LOCALLY FOR CLARITY)

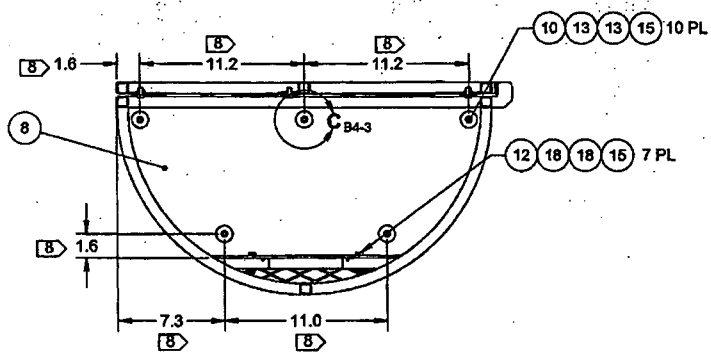
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-810	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET EQUIPMENT INSTALLATION	NTS
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8 7 6 5 4 3 2 1

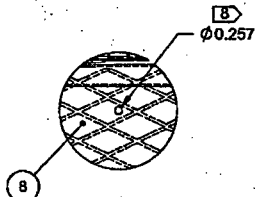
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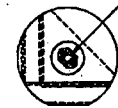
SECTION A-A B8-2



SECTION B-B A8-3



DETAIL C B7-3



DETAIL D C3-3

TRANSFER MARK FROM
NUTPLATES ON LID AND DRILL
Ø0.257 - Ø0.281 THRU ITEM 6
16 PL

66062

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2011-03-02

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